

Work Order ID 126579

November-14-14 7:56:34 AM

Pls Ship today

126579

Page 1

Item ID: D4961-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Tube Assembly
 Start Date: 11/14/14 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 11/17/14 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: *W* Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4961	A

110 0.00

110

Small Fab

Small Fab

Memo

1- Cut D4961-1 tube to size as per dwg

2- On one side of tube flare end as per dwg then slide sleeves and nuts, flare other side of tube as per dwg.

1 FF NOV 18 2014

120 QC5- Inspect part completeness to step on W/O 0.00

120

QC

Quality Control

Memo

0.00

1 DAS 33 9-89

14-11-18

130 Identify as per dwg & Stock Location: *st 140* 0.00

130

Packaging

Packaging

Memo

0.00

1 DAS 27 11-18

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

MJS *14-11-18*
MF
14-11-18

Picklist Print

November-14-14 7:56:33 AM

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Work Order ID: 126579

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Parent Item: D4961-041

D4961-041

Parent Item Name: Tube Assembly

Start Date: 11/14/14

Required Date: 11/17/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 13.10.22 NEW ISSUE DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN818-L12J		Purchased	No				Each	0.0000		2			
AN818-1 12.1									**	2	FF	NOV 18 2014	
Nut													
M304TR0.750W.049		Purchased	No			110	f	453.7518	0.7	1			
M304TR0 750W 049									**		FF	NOV 14 2014	
304 RD Tube .750 x .049W													

Location	Loc Qty	Loc Code
MAT017	453.7518	
124768	49.27	
M126183	1.4399	
M128084	14.5819	
M129188	29.5	
M129363	158.96	
M130292	200	

MS20819-12J		Purchased	No			110	Each	6.0000	2	2			
MS20819-12.1									**		FF	NOV 14 2014	
Sleeve													

Location	Loc Qty	Loc Code
ST306	6	
m129339	6	

Linda Lacelle

From: Mike Petsche
Sent: November-13-14 8:47 AM
To: Linda Lacelle; Sian Willems; Marc Bellavance
Subject: EAPS thing - D4961

Linda

Stocker has a drawing update in the works. But it's stuck with David and he's up to his eyeballs in 407HP

It's the little chunk of rigid pipe for the EAPS. D4961-041 tube assy. Stocker has changed the p/n for the coupling nut to **AN818-L12J**. The only difference between this and the original one is that it is drilled for lockwire. The rest of the tube assy is the same.

Sian needs one (with the drilled coupling nuts) out at Eagle for the install that marc is witnessing next week. Would it be possible to have one made?

We can sign off the p/n change as a deviation.

MIKE PETSCHKE

Director of Engineering - Hawkesbury

DART AEROSPACE

T 1 613 632-5200 > 250

M 1 514 833-1657

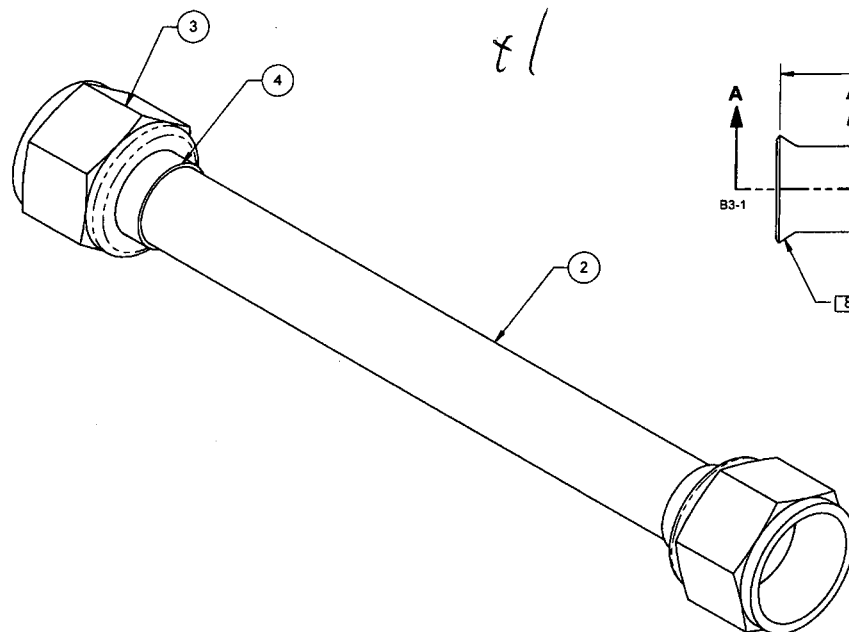
F 1 613 632-4443

1 800 556- 4166

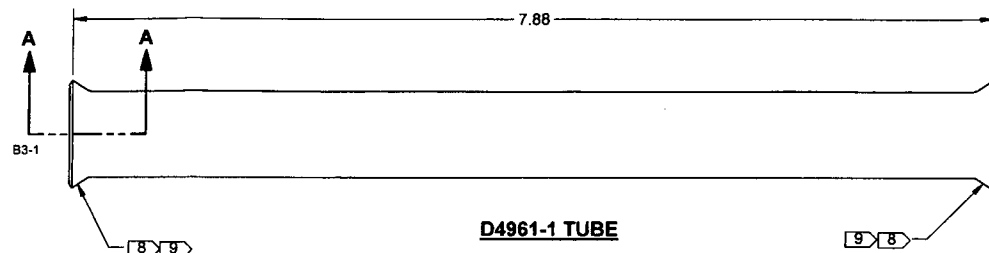
www.dartaerospace.com

ITEM	QTY	P/N	DESCRIPTION
1	X	D4961-041	TUBE ASSEMBLY
2	1	D4961-1	TUBE
3	2	AN818-12J	NUT
4	2	MS20819-12J	SLEEVE

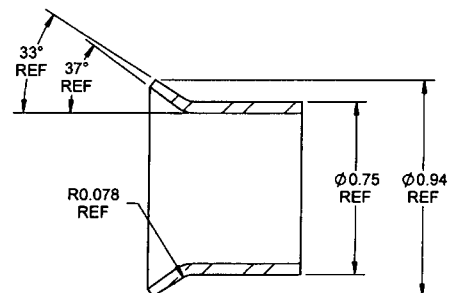
AN818-12J



D4961-041 TUBE ASSEMBLY



D4961-1 TUBE



SECTION A-A
CS-1

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SEAMLESS ROUND TUBING, $\phi 0.750 \times 0.049$ WALL PER ASTM A213 OR ASME SA213 OR ASTM A269 (REF DART SPEC M304TR)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.59 lbs
- 8) FLARE TUBE PER MS33584
- 9) CLEAN INSIDE OF TUBE AFTER FLARING ENDS

126579

A		NEW ISSUE		VS	13.10.21
REV.	DESCRIPTION			BY	DATE
DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4961 REV. A SHEET 1 OF 1 TITLE TUBE ASSEMBLY SCALE NTS			
DRAWN	VS				
CHECKED	RF				
MFG. APPR.	DD				
APPROVED	HS				
DE APPR.	DS				
DATE		13.11.01			

RELEASED
2014-01-06

